




Work Order ID 55284

January 12, 2010 3:59:24 PM

Page 1

Item ID:	D4044-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Fwd Rib Assembly				Stop	
Start Date:	1/12/10	Start Qty:	1.00		Cust Item ID:	
Required Date:	1/25/10	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-1-12	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4044	PAT PA3	10/01/27							

100		0.00							
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Large Fab		0.00							
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Large Fab									
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Memo

- 1- Cut tube 60" and remove identification markings ✓
- 2- Bend tube with manuel pipe bender as per dwg D4044-1 ✓
- 3- Drill and chamfer holes as per dwg D4044-1 ✓
- 4- Trim access tube material to finish size as per dwg D4044 ✓
- 5- weld bushing as per dwg D4044
- A/R S.S. rod Batch: M105213
- 6- grind welds flush

110	QC5- Inspect part completeness to step on W/O	0.00							
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QC		0.00							
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Quality Control									
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Memo

MATERIAL CERTIFICATION
REQD UPON DELIVERY

PD 10 01.26 ①

10/01/26

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 55284


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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							<i>10/01/26</i>
130  Packaging Packaging	Identify as per dwg & Stock Location: <i>Basket</i> Memo	0.00 0.00							<i>10/01/26</i>
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>Prototype test 10.01.30</i>

IVE RECALL
AUTH 
DATE _____

MUF
10-1-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 12, 2010 3:59:27 PM

Work Order ID: 55284

Parent Item: D4044-041

Parent Item Name: Fwd Rib Assembly


Comments: IPP RevA: new issue DD 10/01/05 verified by:EC

Start Date: 1/12/10

Required Date: 1/25/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1  Bushing		Manufactured	No			100	Each	31.0000	3.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

31



53442

2

54072

29

B 55256 PD 10.01.26

D4021-9  Bushing		Manufactured	No			100	Each	0.0000	4.0000			
M304TS0.750W.049  304 SQ Tube .75x.75x.049W		Purchased	No			100	f	48.4054	5.2632			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

48.4054

103240

1.5816

106604

4.9307

107460

29.2779

109087

12.6152

M113163 PD 10.01.26

~~PD 10.01.26~~

B 55613 PD 10.01.26

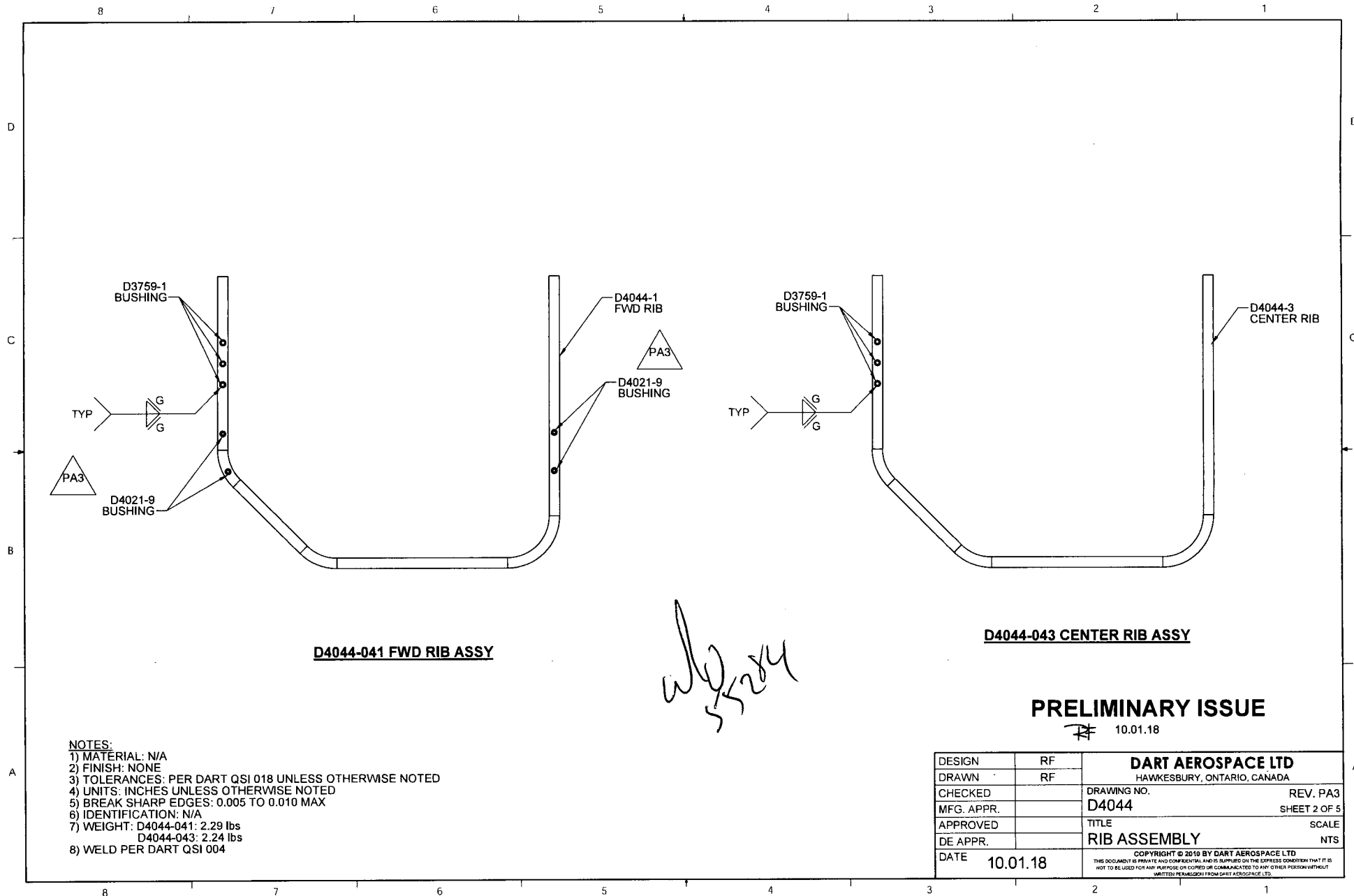
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NOTE: Date & initial all entries



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D4044-041: 2.29 lbs
D4044-043: 2.24 lbs
 - 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D4044	REV. PA3
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
DATE	10.01.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Jan 25 10 01:56p

p.3

PHOENIX TUBE COMPANY, INC.
Manufacturer of Stainless Ornamental and Structural Tubing

CERTIFICATION OF TEST

Sold To: MAGNA STAINLESS INC.
5775 RUE KIERAN

SAINT-LAURENT QC H4S
CAN

CUSTOMER ORDER#: PO08691
DATE SHIPPED: 02/23/10
SIZE: 3/4SQ X 18 GA AW
SOURCE: USA D
VENDOR: NAS

Specification:

ASTM A554-08a

NO WELD REPAIR

Ship To: MAGNA STAINLESS INC.
5775 RUE KIERAN

SAINT-LAURENT QC H4S
CAN

Phone# 3391211 Ext:
ORDER#: 209402
QTY SHIPPED: 300.0
GRADE: 304 WELD: HF
HEAT#: 3DK8
TEST REPORT#: TR007424
Report Date: 11/28/07

WELDED / MILL-FINISH

OK P 10.01.26

PO08691

MERCURY IS NOT USED BY US AS AN ALLOYING MATERIAL NOR IS METALLIC MERCURY HANDLED IN THE VICINITY OF OUR PROCESSING LINES. WE ARE NOT PRESENTLY AWARE OF ANY MERCURY CONTAMINATION.

Chemical Analysis

C	MN	P	S	SI	CR	NI	MO	CU	CO	N2
.058	1.564	.028	.015	.267	18.363	8.14	.256	.298	0	.042

Physical Analysis

Hardness	YIELD		TENSILE		OTHER	
	PSI	MPA	PSI	MPA	Percent EL	Percent RA
RB 86	49780	0	99490	0	54.1	0

THE CHEMICAL ANALYSES ARE CORRECT AS CONTAINED IN OUR CORPORATE RECORDS.
PHYSICAL PROPERTIES ARE DETERMINED WHILE MATERIAL IS IN STRIP FORM.
Melted & Manufactured In the USA FAR BAA complies, DFARS BAA complies, FAR TAA complies

CERTIFIED BY:

Sam L...

1185 WIN DR, BETHLEHEM, PA., 18017 - (610) 865-5337
FAX NUMBER: 610-865-4073

Sq. mill finish